



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 61669

Tuesday, August 31, 2010 10:44:53 AM



Page 2

Item ID: D3391-025

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Tube Assembly

Start Date: 8/31/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1  Memo 1-Machine as per Folio FA 599 Rev: <u>AA</u> 2-Debur	0.00  0.00							
				<u>SL</u>	<u>11/02/14</u>	<u>①</u>			
130  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00		<u>SL</u>	<u>11/02/14</u>				
140  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		<u>SL</u>	<u>11/02/14</u>	<u>1</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



**Work Order ID 61669**

Tuesday, August 31, 2010 10:44:53 AM




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Item ID: D3391-025 Accept  Setup Start   
Revision ID: Stop   
Item Name: Aft Tube Assembly  
Start Date: 8/31/2010 Start Qty: 1.00  Cust Item ID:  
Required Date: 9/7/2010 Req'd Qty: 1.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150	Skidtubes	0.00							
	Skidtubes								
Skidtubes	Memo 1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803	0.00							

11-2-23

160	BENDING MACHINE - SKIDTUBES	0.00							
	CNC Bend 1								
CNC Delta 100 Bender	Memo Form as per Dwg D3391 Using Bend Prog 3391025	0.00							

11-2-23

170	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo	0.00							

4.275

① 8 BE 11/02/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**Work Order ID 61669**

Tuesday, August 31, 2010 10:44:53 AM



Page 4

Item ID: D3391-025

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Tube Assembly

Start Date: 8/31/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217  
Wearplate Jig .

\*\*\*\*\*Do Not Open To Finished Size\*\*\*\*\*

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2  
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per  
Dwg D3391.

7-Deburr

1 10 BEN/03/4

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 61669**

Tuesday, August 31, 2010 10:44:53 AM



Page 5

Item ID: D3391-025

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Tube Assembly

Start Date: 8/31/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/10/15

(80)

Quality Control

200

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1

JB 11/03/15

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

1

P

AE 11/03/15

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID -61669**

Tuesday, August 31, 2010 10:44:53 AM



Page 6

Item ID: D3391-025

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Tube Assembly

Start Date: 8/31/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220



Skidtubes

Skidtubes

0.00

Memo

0.00

Instal spacers as per dwg D3391

A/R Magnabond 6398 Batch: 116227

exp. date: 08/20/11

cure time 12hrs as per QSI0015

Skidtubes

230



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

235



HandFinish

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

Hand Finishing

AND REALODINE AS PER PAR09-043

1 0 BE 11/03/15

11 03 16 17

1 BR 11-3-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Work Order ID 61669**




Tuesday, August 31, 2010 10:44:53 AM



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Item ID: D3391-025 Accept  Setup Start   
Revision ID: Stop   
Item Name: Aft Tube Assembly  
Start Date: 8/31/2010 Start Qty: 1.00  Cust Item ID:  
Required Date: 9/7/2010 Req'd Qty: 1.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M115951</i> Memo START TIME: <i>3:45</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>4:15</i>	0.00  0.00				<i>1</i>		<i>11-3-16</i>	
250  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				<i>1</i>	<i>0</i>	<i>11</i>	<i>103/17</i>
260  HandFinish Hand Finishing	HandFinishing  Memo ✓ 1-Install inserts as per Dwg D3391 ✓ 2-Install Aft Cap as per Dwg D3391 ✓ A/R Sikaflex-241/-291 <i>11/11/09 040</i> Sikaflex expiry date: <i>11/09</i>	0.00  0.00				<i>1</i>	<i>0</i>	<i>11</i>	<i>103/17</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 61669**

Tuesday, August 31, 2010 10:44:53 AM



Page 8

Item ID: D3391-025

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Tube Assembly

Start Date: 8/31/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

270



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Suloz 10/3/17

Memo

0.00

2

280



Packaging

Packaging

Identify as per dwg &amp; Stock Location: w/o 13064979

0.00

Memo

1

P

11/03/17

290



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/13/17

11/03/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, August 31, 2010 10:44:57 AM

Page 1

Work Order ID: 61669

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly



Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC  
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM ☐ ☐ ☐  
 IPP rev D 07.03.20 revF dwg EC  
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD  
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC  
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6014-090  ALUMINUM EXTRUSION		Manufactured	No			100	Each	29.0000	1				
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>LG</div> <div>29</div> <div></div> </div> <div> <div>56572</div> <div>29</div> <div></div> </div>													
D3670-4:200  (SPACER)		Manufactured	No			230	Each	64.0000	4	4			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>LG</div> <div>64</div> <div></div> </div> <div> <div>57349</div> <div>64</div> <div></div> </div>													
D2646  Aft Cap		Manufactured	No			270	Each	71.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>FP-4</div> <div>62</div> <div></div> </div> <div> <div>57332</div> <div>62</div> <div></div> </div> <div> <div>FP6</div> <div>9</div> <div></div> </div> <div> <div>52663</div> <div>9</div> <div></div> </div>													

LAST ONE  
left in batch!

11/2/15

DE 11/03/15  
B-66041 (4)

11/03/17

X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Tuesday, August 31, 2010 10:44:57 AM

Work Order ID: 61669



Parent Item: D3391-025



Parent Item Name: Aft Tube Assembly

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

270

Each

8.0000

1

1



Wearpad



xl 11/03/17

Location

Loc Qty

Loc Code

FP

1

1365057

xl

55465

1

FP17

7

57713

3

60491

4

D3537-7

Manufactured No

270

Each

17.0000

1

1



Wearpad



xl 11/03/17

Location

Loc Qty

Loc Code

FP

7

46346

7

FP16

10

56831

10

xl

D3553-1

Manufactured No

270

Each

43.0000

1

1



Gasket



xl 11/03/17

Location

Loc Qty

Loc Code

FP

43

33868

1

56568

42

xl

D3553-3

Manufactured No

270

Each

47.0000

1

1



Gasket



xl 11/03/17

Location

Loc Qty

Loc Code

FP

47

53480

47

xl

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, August 31, 2010 10:44:57 AM

Work Order ID: 61669

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No

270 Each

917.0000 2 2



Phenolic Washer



Handwritten: 11/03/17

Location

Loc Qty

Loc Code

ST077

917

42329

150

52505

767

Handwritten: x2

ALS4-1032-130 Purchased No

260 Each

3,094.000 14 14



Insert



Handwritten: 11/03/17

Location

Loc Qty

Loc Code

PKG11

2902

114723

2902

ST282

153

110511

10

114407

143

ST381

39

114654

39

Handwritten: 1116864

Handwritten: x14

ALS4-1032-225 Purchased No

270 Each

5,418.000 12 12



Insert



Handwritten: 11/03/17

Location

Loc Qty

Loc Code

PK011

5418

110768

5418

Handwritten: x12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, August 31, 2010 10:44:57 AM

Work Order ID: 61669



Parent Item: D3391-025



Parent Item Name: Aft Tube Assembly

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

270

Each

1,567.000

6

6



BOLT



24 11/03/17

Location

Loc Qty

Loc Code

ST303

500

1117010

x6

115438

500

ST350

1067

114108

14

114416

12

114523

2

114941

39

115300

1000

AN3C5A

Purchased

No

270

Each

1,072.000

4

4



Bolt



24 11/03/17

Location

Loc Qty

Loc Code

ST350

1062

114330

11

115015

251

115108

300

115316

300

115371

100

115422

100

ST351

10

113121

10

1115835

x4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Page 5

Tuesday, August 31, 2010 10:44:57 AM

Work Order ID: 61669



Parent Item: D3391-025



Parent Item Name: Aft Tube Assembly

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased

No

270

Each

155.0000

10

10



washer



yl 1103/17

Location

Loc Qty

Loc Code

ST245

155

107534

29

109545

54

111548

72

M 116304

x10

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 61669
<b>Description:</b> Float Skidtube (412)		<b>Part Number:</b> D3391-3
<b>Inspection Dwg:</b> D3391	<b>Rev:</b> H	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<b>Lathe Section</b>						
14.000	+/-0.010	14.00	✓		Gage	SA-1
3.500	+/-0.010	3.475	✓		Vern	SA-5
88.93	+/-0.030	88.93	✓		Gage	SA-1
<del>44.995</del>	<del>+/-0.030</del>					
Ø3.200	+/-0.010	Ø3.206	✓		Vern	SA-5
<del>88.93</del>	<del>+/-0.030</del>					
Ø3.750	+/-0.010	Ø3.748	✓		Vern	SA-5
30° x 160° chamfer	+/-0.010	30° x 160°	✓		Vern	SA-5

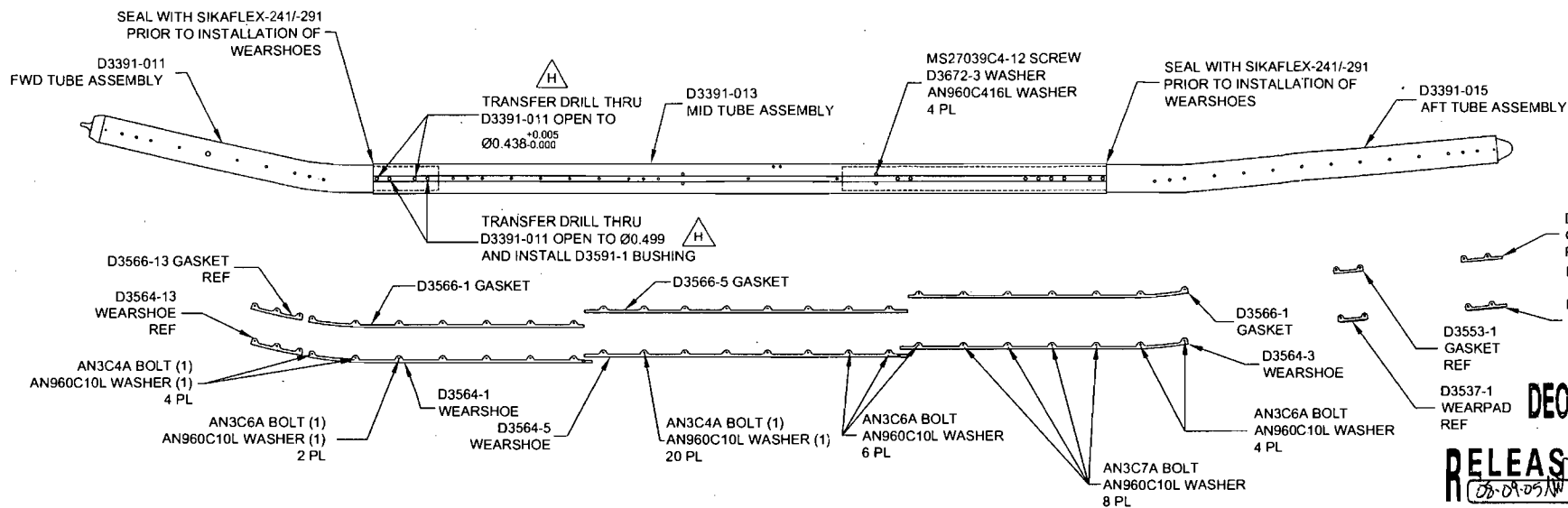
<b>Measured by:</b> SL	<b>Date:</b> 10/1/50
<b>Audited by:</b>	<b>Date:</b>

<b>HAAS Section</b>						
1.526	+0.000/-0.030	1.515	✓		Vern CNC-02	
7.500	+/-0.010	7.500	✓		"	
27.750	+/-0.010	27.750	✓		m-type	
31.750	+/-0.010	31.750	✓		"	
35.250	+/-0.010	35.250	✓		"	
3.300	+/-0.010	3.300	✓		Vern CNC-02	
0.200	+/-0.010	.201	✓		"	
3.520	+/-0.010	3.517	✓		mic JLM4	
0.687	+0.010/-0.000	.693	✓		Vern CNC-02	
R0.062	+/-0.010	.062	✓		R-G	
Ø0.484	+0.005/-0.001	.487	✓			

<b>Measured by:</b> SL	<b>Date:</b> 11/02/14
<b>Audited by:</b> ml	<b>Date:</b> 11.2.5

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	SL








**D3391-041 ASSEMBLY**

**D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

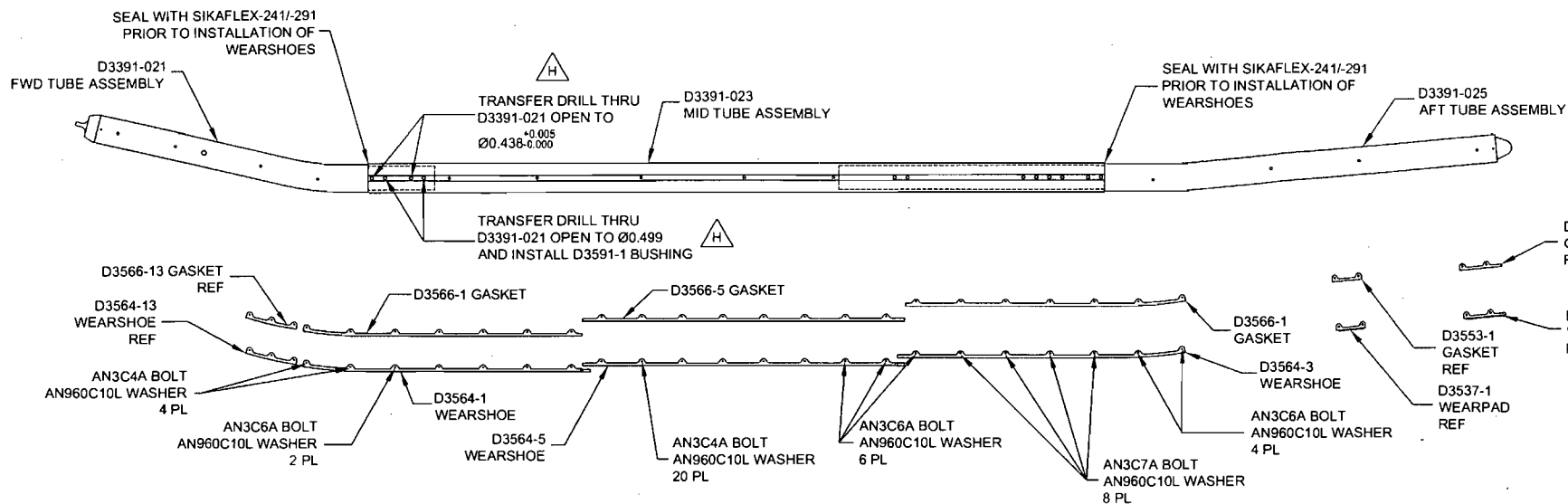
**GENERAL NOTES**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 1 OF 8
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DE APPR.		412 FLOAT SKIDTUBE	NTS
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**DEO ATTACHED**  
**RELEASED**  
08-08-20

*who 6/6/69*



**D3391-043 ASSEMBLY**

**D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3566-13	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

**GENERAL NOTES**

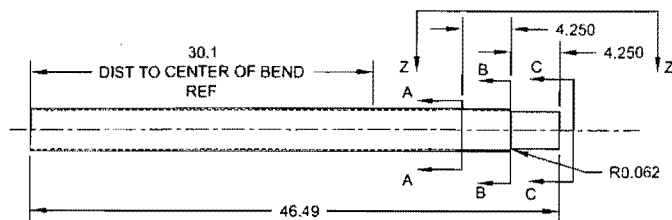
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

DEO ATTACHED

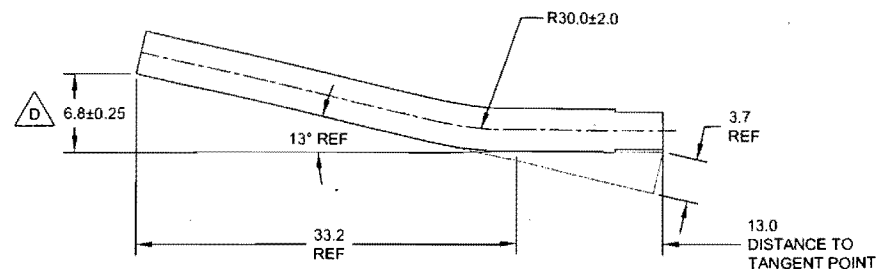
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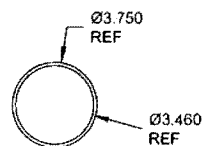
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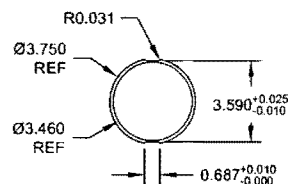
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



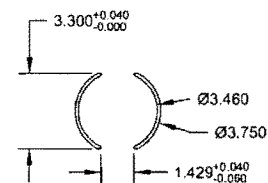
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



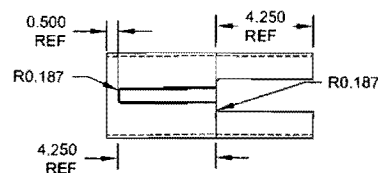
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**SECTION B-B**  
SCALE 2X



**SECTION C-C**  
SCALE 2X

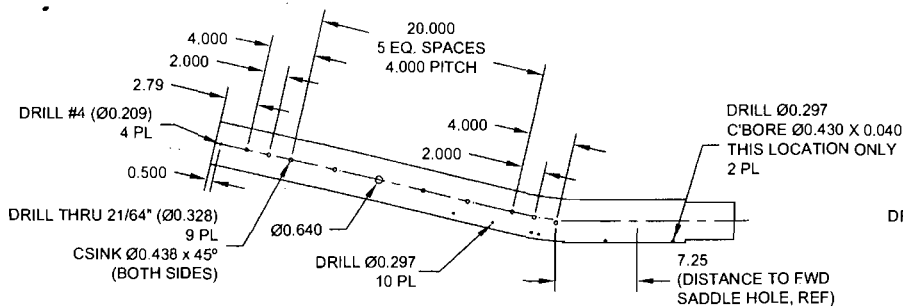


**VIEW Z-Z**  
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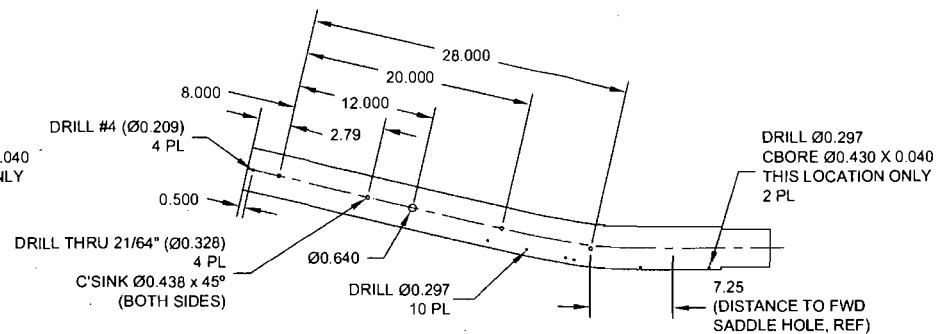
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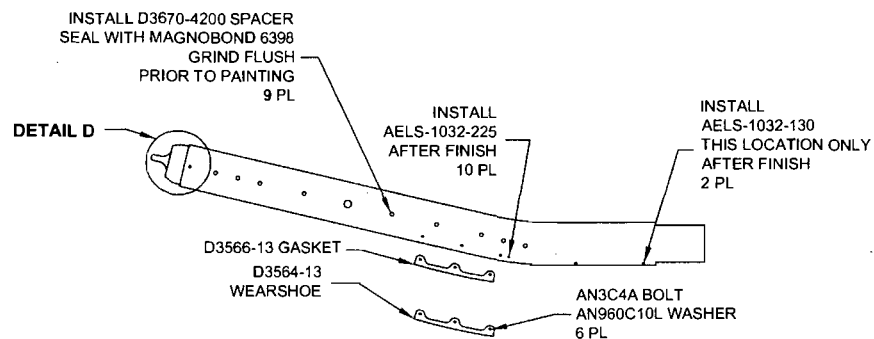
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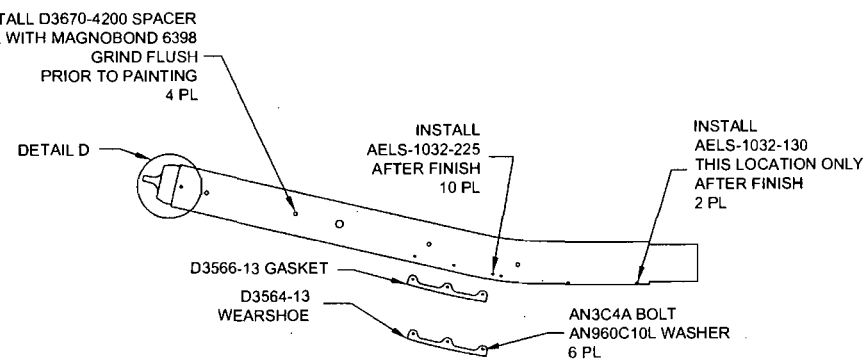
**D3391-011 DRILLING DETAIL**



**D3391-021 DRILLING DETAIL**



**D3391-011 ASSEMBLY DETAIL**

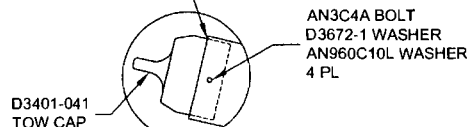


**D3391-021 ASSEMBLY DETAIL**

**D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST**

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
		D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
2	2	AELS-1032-130	INSERT
10	10	AELS-1032-225	INSERT

SEAL WITH  
SIKAFLEX-241/291



**DETAIL D  
SCALE 2X**

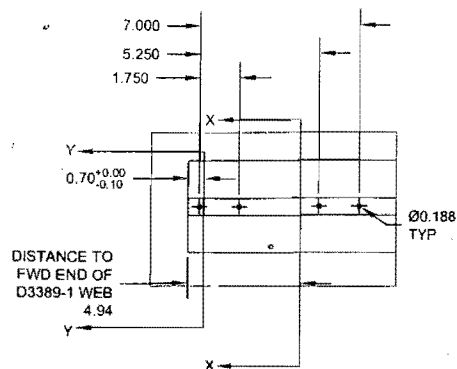
*61669*

**DEO ATTACHED**

**RELEASED**  
08-09-05 M

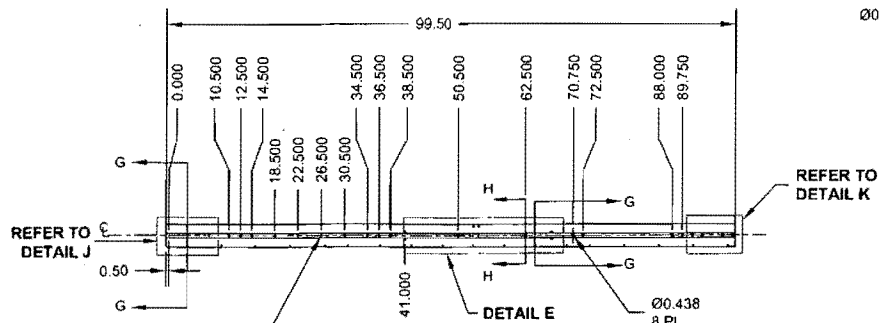
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MFG. APPR.		D3391	SHEET 4 OF 8
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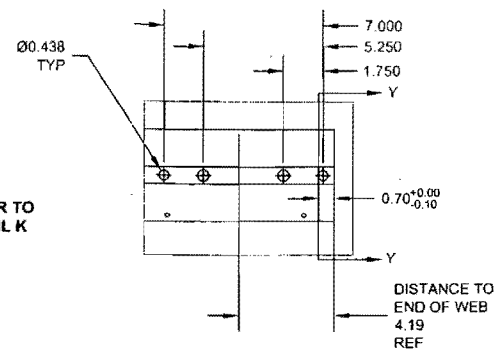


DETAIL J  
SCALE 4X

DRILL THRU 21/64" (Ø0.328)  
CSINK Ø0.438 X 45° (BOTH SIDES)  
12 PL



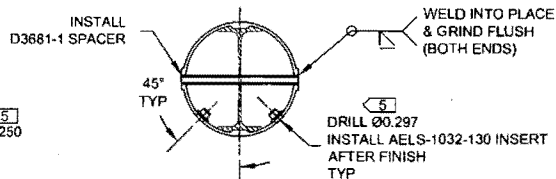
D3391-013 ASSEMBLY DETAIL



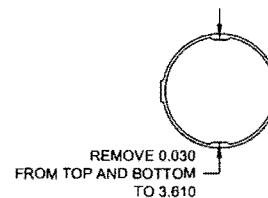
DETAIL K  
SCALE 4X



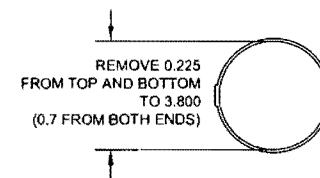
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SCALE 5X



SECTION H-H  
SCALE 5X



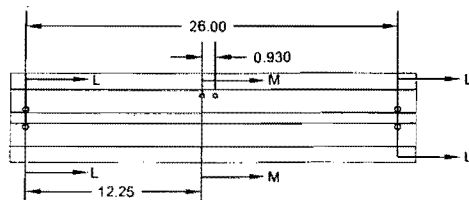
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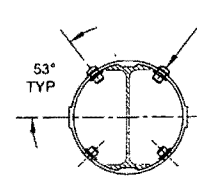
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D3391-013 MID TUBE ASSEMBLY PARTS LIST

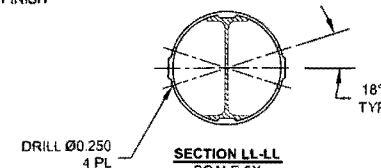
QTY	PART NUMBER	DESCRIPTION
-013		
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



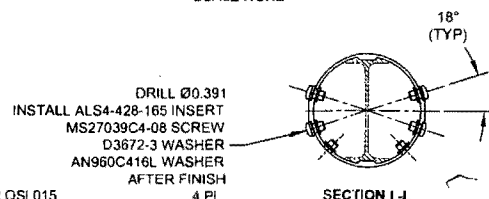
DETAIL E  
SCALE NONE



SECTION M-M  
SCALE 5X



SECTION LL-LL  
SCALE 5X



SECTION L-L  
SCALE 5X

D3391-013 MID TUBE ASSEMBLY

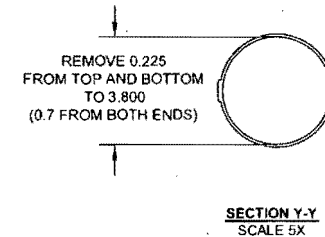
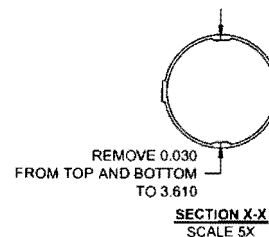
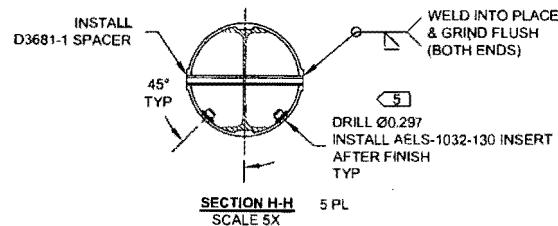
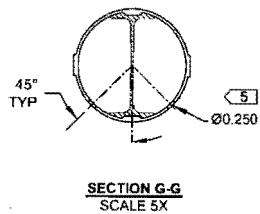
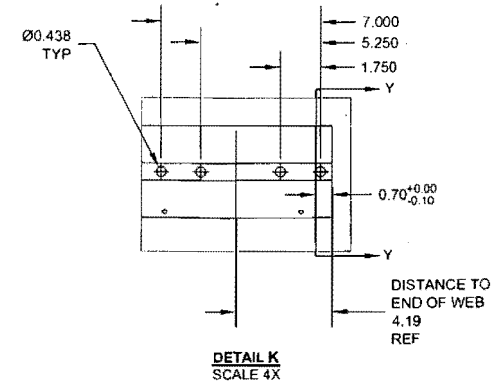
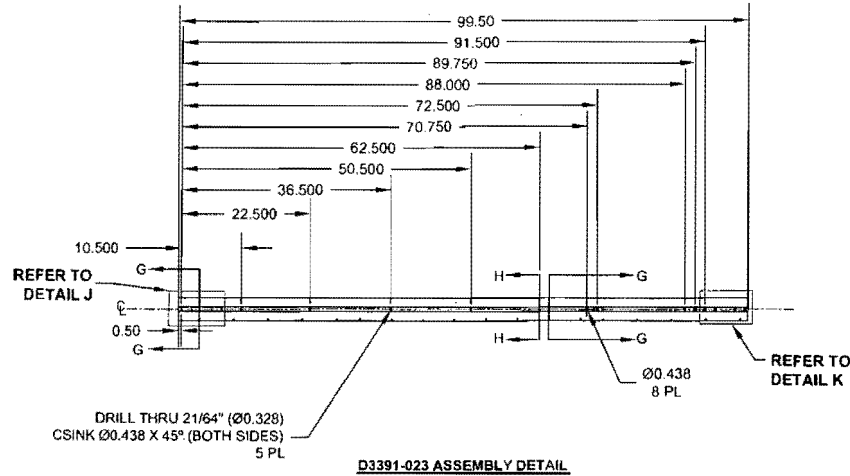
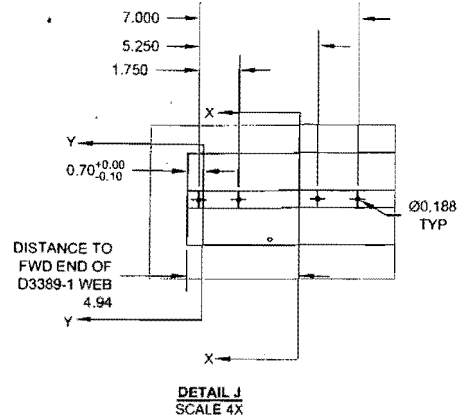
- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- WELDING: PER DART QSI 004

DEO ATTACHED

RELEASED  
08-09-10

DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	AJS	PORT HADLOCK, WA
CHECKED		DRAWING NO. REV. H
MFG. APPR.		D3391 SHEET 5 OF 8
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**D3391-023 MID TUBE ASSEMBLY PARTS LIST**

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

**D3391-023 MID TUBE ASSEMBLY**

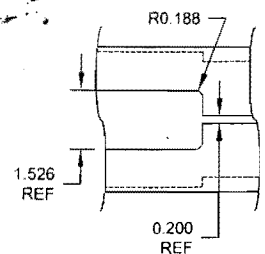
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

DEO ATTACHED  
**RELEASED**  
08-08-20

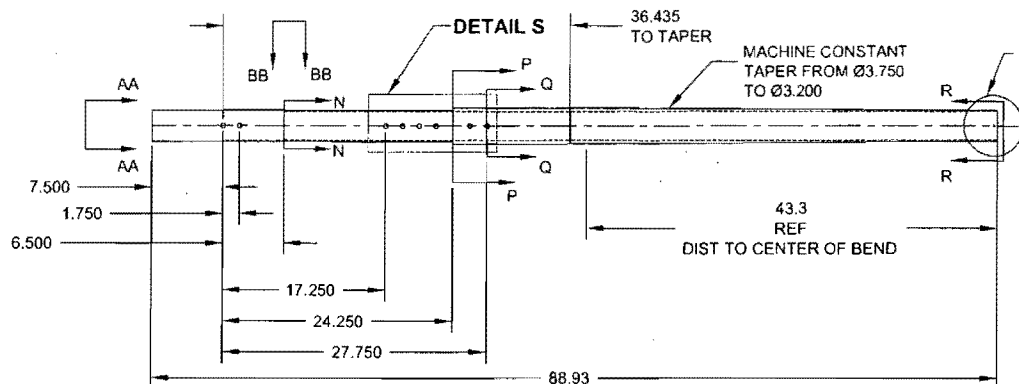
DESIGN	PH	<b>DART AEROSPACE USA, INC</b>
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CHECKED		DRAWING NO. REV. H
MFG. APPR.		D3391 SHEET 6 OF 8
APPROVED		TITLE SCALE
DATE	08.08.20	412 FLOAT SKIDTUBE NTS

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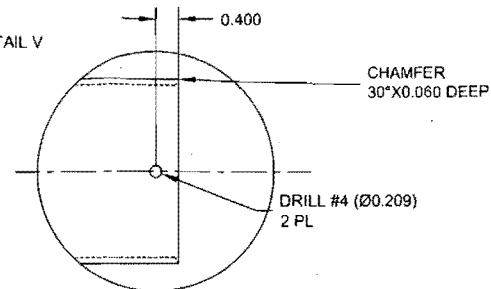
621669



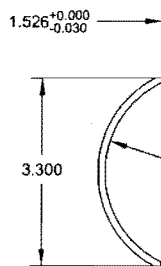
**VIEW BB-BB**  
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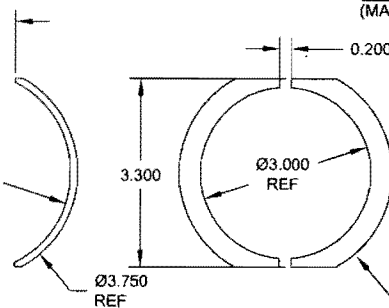
**D3391-3 AFT DRILLING AND CUTTING DETAIL**  
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



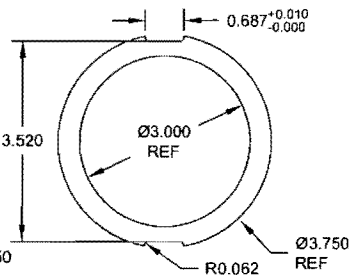
**DETAIL V**  
SCALE 6X



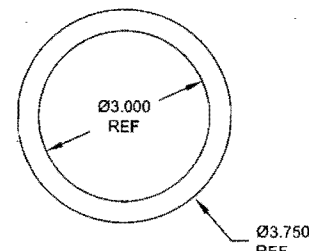
**SECTION AA-AA**  
SCALE 6X



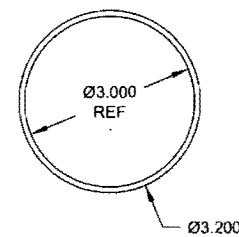
**SECTION N-N**  
SCALE 6X



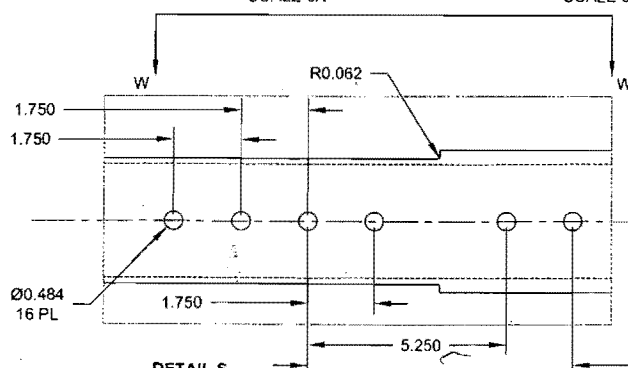
**SECTION P-P**  
SCALE 6X



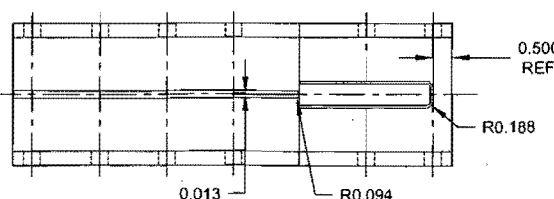
**SECTION Q-Q**  
SCALE 6X



**SECTION R-R**  
SCALE 6X



**DETAIL S**  
SCALE 4X



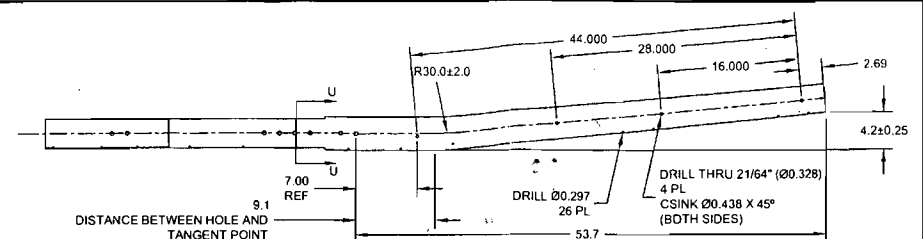
**VIEW W-W**  
SCALE 4X

DEO ATTACHED

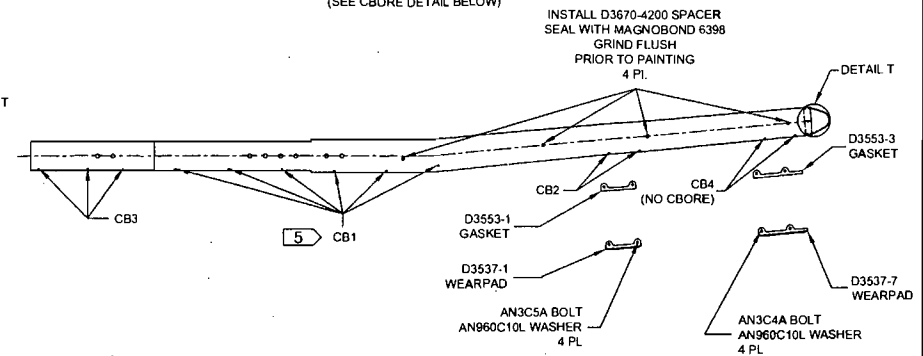
RELEASED  
28-09-05

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D3391	REV. H
MFG APPR.		SHEET 7 OF 8	
APPROVED		TITLE	
DE APPR.		412 FLOAT SKIDTUBE	
DATE	08.08.20	NTS	

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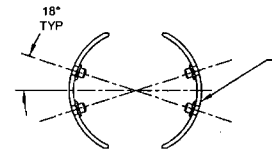


**D3391-025 BENDING AND DRILLING DETAIL**  
(SEE CBDR DETAIL BELOW)

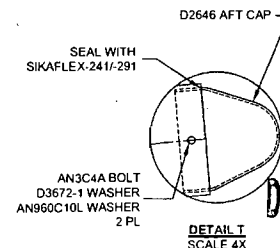


**D3391-025 ASSEMBLY AND CBORE DETAIL**  
(SEE TABLE)

QTY -	QTY -	PART NUMBER	DESCRIPTION
X	025		
		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2846	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4		AL54-428-166	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER



**SECTION CC-CC**  
**SCALE 3X**



**DETAIL T**  
**SCALE 4X**

DEO ATTACHED

RELEASED  
08-09-05/14

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AS	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG APPR.	<i>[Signature]</i>	D3391	SHEET 8 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR	<i>[Signature]</i>	412 FLOAT SKIDTUBE	NTS
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DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>JP</i>	CHECKED <i>h</i>	MFG. APPR. <i>h</i>	APPROVED <i>h</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE 09.09.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

**PURPOSE:**

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

**CHANGE:**

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~  
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~  
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS  
OFF POWDER COATING WITH MEK DEGREASER.

**RELEASED**  
2010-02-02  
*h*

*66669*